

Work Order ID 57332-2

April 5, 2010 2:40:12 PM

Page 1

Item ID: D2646

Accept

Revision ID:

Item Name: Aft Cap

Start Date: 05/04/2010 Start Qty: 50.00

Required Date: 09/04/2010 Req'd Qty: 50.00

Reference:

Approvals: Process Plan:

Date: 10-4-05 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2646

Rev C

100



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: 11583 1-Spin as per Dwg D2646 12-Material release note required

10-4-05

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure Material Release Note is attached

10/4/21 (100)

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

S104043

counts
7100
QSP019

SIEG

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 57332

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Page 2

Item ID: D2646

Accept



Setup Start



Revision ID:

Item Name: Aft Cap

Stop



Start Date: 05/04/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

1-Drill using DT8026 as per Dwg D2646. 2-Open holes to .297 as per Dwg D2646. 3-Deburr

Ep 5/10/05/03 (100)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/05/03

counted (100)

as per

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

(100) 10-5-4

W/O:		WORK ORDER CHANGES						
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Work Order ID 57332

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

12114207

0.00

=> All 10/05/13

100

9

START TIME:

10:30PM

OVEN TEMPERATURE:

FINISH TIME:

320°F

170

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

① BR 10-5-07

180

Small Fab

0.00



Small Fab

Small Fab

Memo

Install inserts as per Dwg D2646

0.00

① BR 10-5-07

W/O:		WORK ORDER CHANGES						
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Work Order ID 57332

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Item ID: D2646

Accept



Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 50.00



Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/05/31

(70)

200



Packaging

Packaging

Identify as per dwg & Stock Location: FD

0.00

Memo

0.00

MF 10-5-31

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/31

MF 10-5-31

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

April 5, 2010 2:40:17 PM

Page 1

Work Order ID: 57332

Parent Item: D2646

Parent Item Name: Aft Cap

Comments: IPP: G05.08.22 Hole size revised in Step 5 KJ/JLM
IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Start Date: 05/04/2010

Required Date: 09/04/2010

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
ALS7-1032-130		Purchased	No			110	Each	645.0000	100.0000			



Insert

ALS4-1032-130

Warehouse

Location

114654

Loc Qty

Loc Code

BR. 10-5-31

Main Warehouse

ST282

645

113238

645

D2646P

Purchased

No

180

Each

0.0000

50.0000



Aft Cap



MF 10-5-31

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO11589**

Purchase Order Date 05/04/2010

PO Print Date 05/04/2010

Page Number 1 of 1

Order From :

VC-SIE001

SIEG'S MANUFACTURING LTD.
6236 - 205 STREET
LANGLEY, BC V2Y 1N7
CA

FAXED
APR 30

Contact Name

Vendor Phone 604 530 7455

Vendor Fax 604 530 7490

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2646P	Aft Cap	07/04/2010 Yes	100.00 Each	Yours ppd	\$5.3500	\$535.00

Special Inst: As Per Dwg: D2646 Rev.C

PO Total: \$535.00

*ASAP please!
thank you*

Change Nbr: 1

Change Date: 05/04/2010

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

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Sieg's Manufacturing Ltd. Packing Slip

Metal Spinning & Fabricating

6236 205 Street

Langley, BC, Canada V2Y 1N7

Phone: (604) 530 7455 Fax: (604) 530-7490

Packing Slip No.:

37785

Date:

04/19/2010

Page:

1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: P011589	Sold By: KAULBARS, ARLA
Shipped By:	Ship Date: 04/19/2010
Tracking No.:	

Item No.	Unit	Description	Quantity
D2646 P	Each	AFT CAP INSPECTION REPORT ATTACHED SOLYB3	100
Comment:			

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Sieg's Manufacturing Ltd.

6236 205 Street Langley, B.C. Canada V2Y 1N7

Ph#: (604)530-7455 fax#: (604)530-7490

arla@siegsmfg.com

INSPECTION REPORT

Date: April 19/2012

Customer: Dart Aerospace

Packing Slip: 37785

8 10/04/23

Part#:	Quantity	Material	Check holes	Insp. By.
<u>D3646P Alt Cap</u>	<u>100</u>	<u>254 11000</u>	<u>✓</u>	<u>D</u>

Notes:

Material Certification Attached: yes

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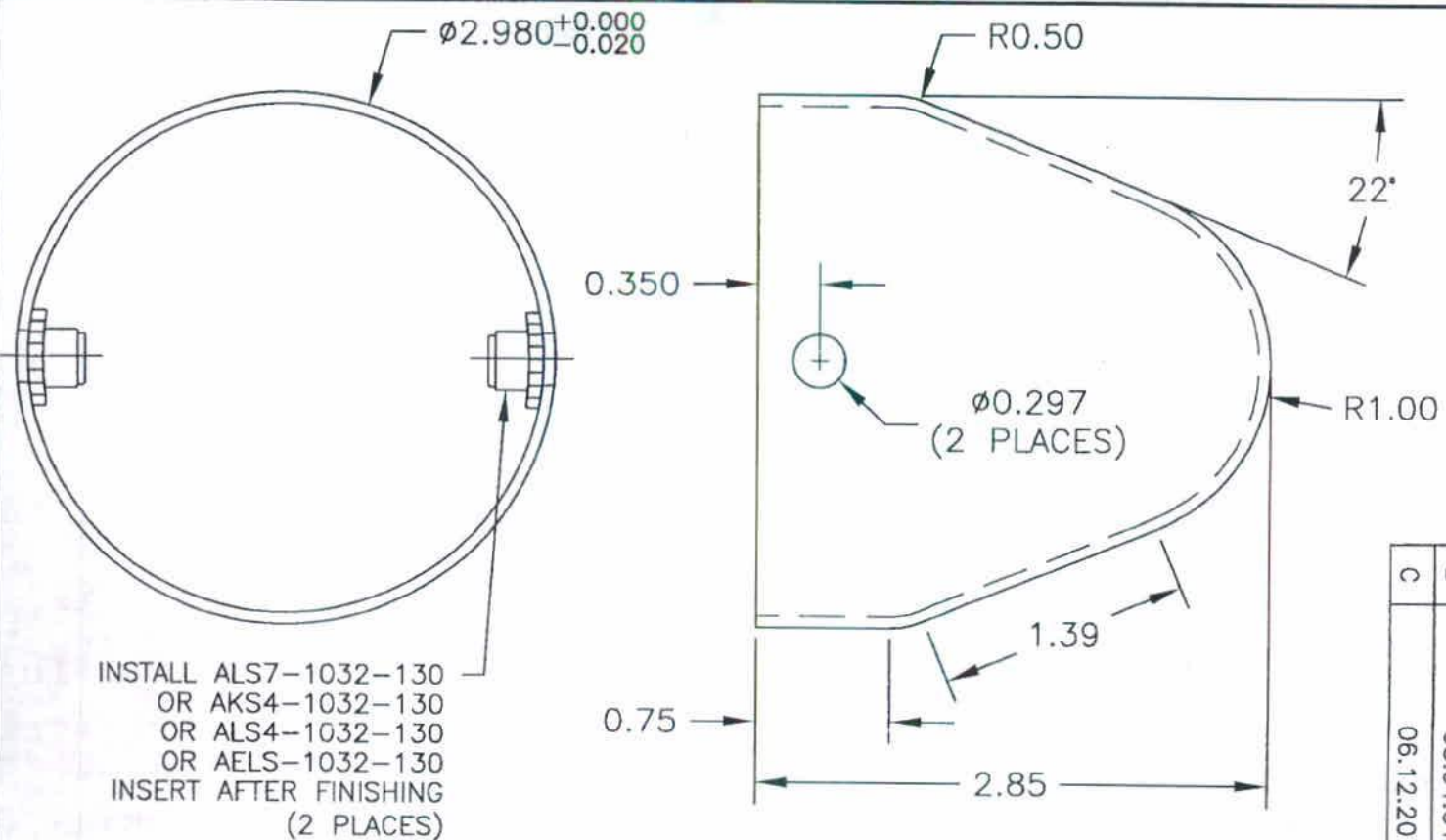
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DART

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.		REV. C
CHECKED		APPROVED		DRAWING NO.	D2646	SHEET 1 OF 1
DATE	06.12.20			TITLE	AFT CAP	
A	97.03.25			NEW ISSUE		
B	05.04.01			CHANGE TO CLOSED INSERTS		
C	06.12.20			CHANGE TO OPEN ENDED INSERTS		



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-O 0.063 THICK (QQ-A-250/1)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

RECEIVED
07.03.12

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